

32

Date: Monday, 7/16/2007 2:41:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HIGH AFT X-TUBE 412
Job Number : 33538	
Estimate Number : 10559	
P.O. Number : <i>N/A</i>	Part Number : D412664203
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D412-664-243 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : D
Previous Run : 32230	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/5/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS	
Est Rev:F 06-03-29 Remove Comments on Pick List JLM	
Est Rev:G 06.12.08 per ECN 886 EC	
Est Rev:H 07-04-30 As per Rev D JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------


KS 07.07.30

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

5 07/10/27

2.0	D6009129	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube *D26548*

Check OD = 3.500"; ID = 2.250"

ultra sonic raw extrusion
B 07.10.10

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

J-F. 07/10/11

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

J-F. 07/10/11

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

J.F. 07/10/11

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243
Cuff(Donot engrave on outside of tube)

Inside of

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/11

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ULTRA SONIC BEFORE BENDING

07/10/11

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-10-11

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ULTRA SONIC BEFORE BENDING

07/10/11

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/A

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect work & Chemical conversion Coat

W/A

11-01-70

4220P

Date: Monday, 7/16/2007 2:41:38 PM
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Process Sheet

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Drawing Name: HIGH.AFT X-TUBE 412

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Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

gal 7-10-12

13.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

10 07-10-12

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

ultra sonic

*EL/SR
7-10-17
TD 7-10-18 RSMIR
OAK
10/11 7-10-12*

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JO 7-10-17

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6 7/10/18

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 7/10/18

18.0 OUTSIDE SERV.10 OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380

Issue P/O: *4852* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

4852 6/20/10/17

Date: Monday, 7/16/2007 2:41:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33538

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

6/10/19
7/10/16 (1)

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

6/10/19

21.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ST 07-10-20

} ST 07-10-21

22.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

JA-10-22 (1)

23.0 D3595 Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total: 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch:

37835

ST 07-10-26

24.0 D2856600 Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total: 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

25656

ST 07-10-26

25.0 D28961 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

30200

ST 07-10-26

Date: Monday, 7/16/2007 2:41:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33538

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 D31891 Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

33561^{v1} / 30201^{x1}

RT 07-10-26

27.0 MS2192028 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

104423

RT 07-10-26

28.0 MS2192030 clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 100154

RT 07-10-26

29.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 104677

Expiry Date: 08-10-01

1:00 pm

RT 07-10-26

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

RT 07-10-26

30.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RT 07-10-26

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Date: Monday, 7/16/2007 2:41:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33538

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104517

AS

33.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100743

AS

34.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M105125

AS

35.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M104374

AS

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/10/25

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 10:00 AM / 07/16/25

SKP
1X

Location:

PPP Rev:

ASG

07/16/25 AS

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33538

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2011.10.29 (1)

Job Completion



W 10.29

DART AEROSPACE LTD	Work Order: 33538
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

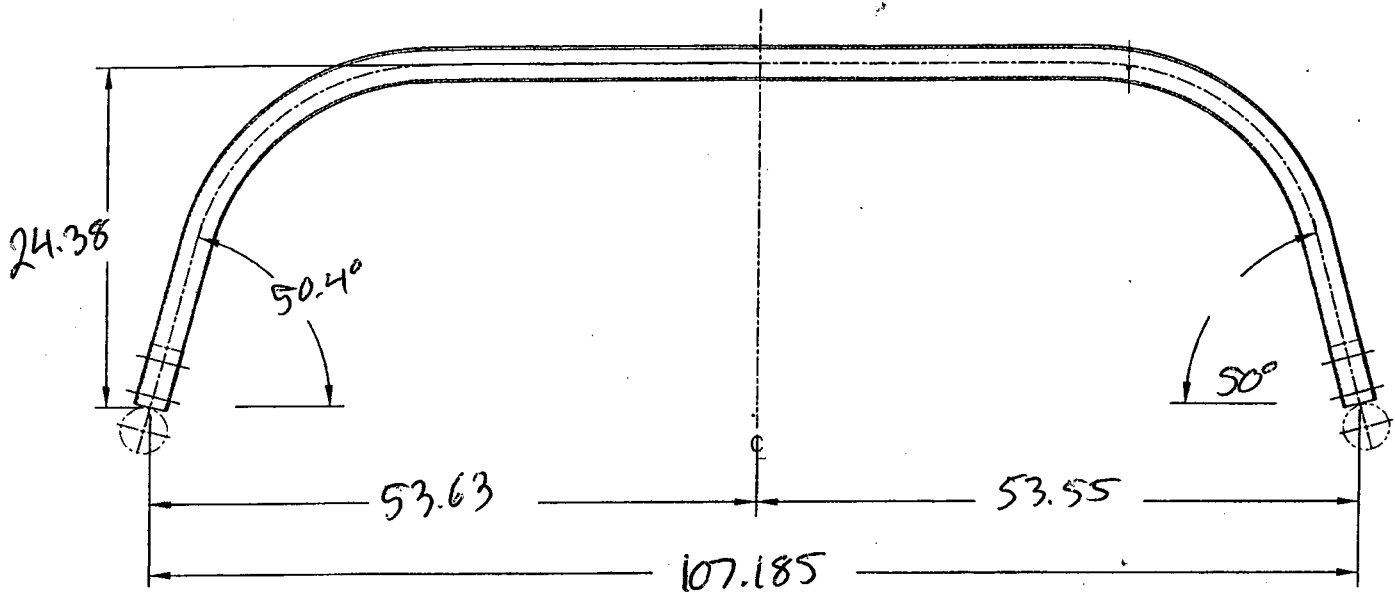
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689	✓			
	2.748	+0.005/-0.000	2.753	✓			
	2.884	+0.005/-0.000	2.888	✓			
	3.019	+0.005/-0.000	3.022	✓			
	3.163	+0.005/-0.000	3.165	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.433	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.621	✓			
	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.500	+/-0.010	R0.500	✓			
	4.971	+/-0.030	4.969	✓			
SIDE B	2.684	+0.005/-0.000	2.689	✓			
	2.748	+0.005/-0.000	2.753	✓			
	2.884	+0.005/-0.000	2.888	✓			
	3.019	+0.005/-0.000	3.023	✓			
	3.163	+0.005/-0.000	3.165	✓			
	3.308	+0.005/-0.000	3.311	✓			
	3.429	+0.005/-0.000	3.432	✓			
	2.990	+0.005/-0.000	2.994	✓			
	2.618	+0.005/-0.000	2.622	✓			
	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.500	+/-0.010	R0.500	✓			
	4.971	+/-0.030	4.965	✓			
	124.09	+/-0.020	124.110	✓			

Measured by: J.F.	Audited by: E	Prototype Approval:	N/A
Date: 07/10/11	Date: 07/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	

DART AEROSPACE LTD		Work Order:	33538
Description: Crosstube High Aft (412)		Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	
Date	07-10-12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

RELEASE

07.04.24

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

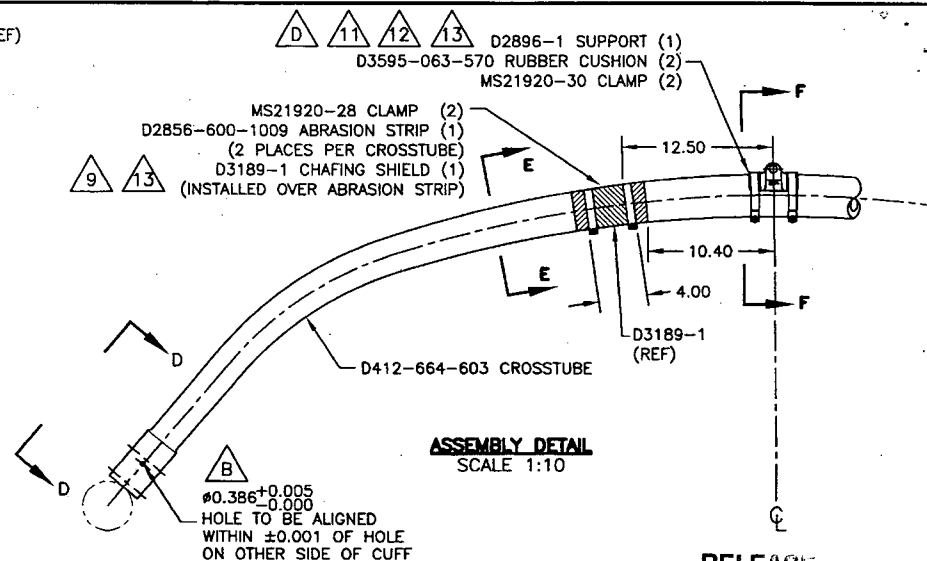
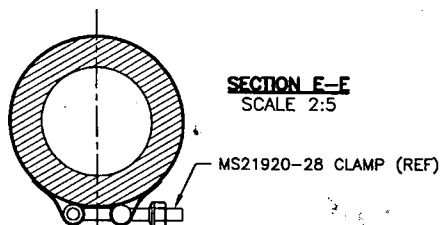
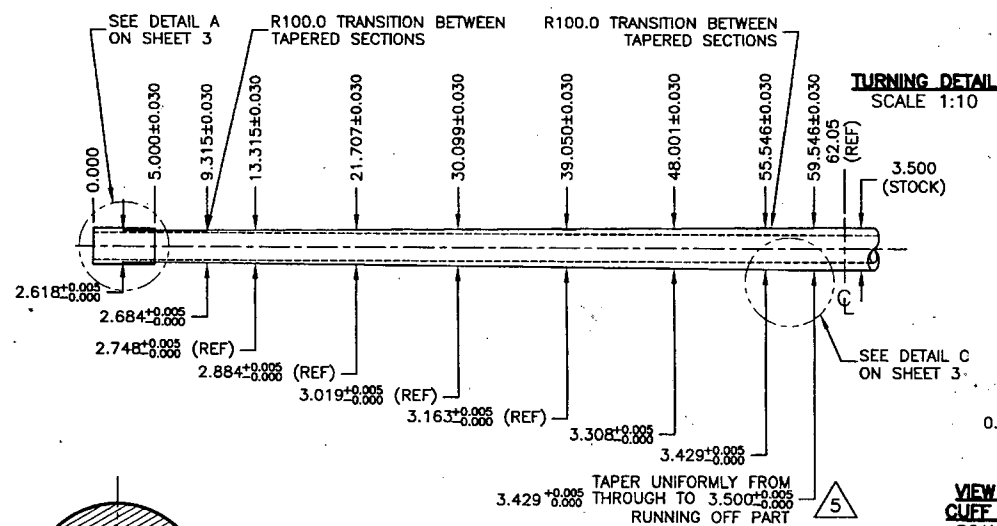
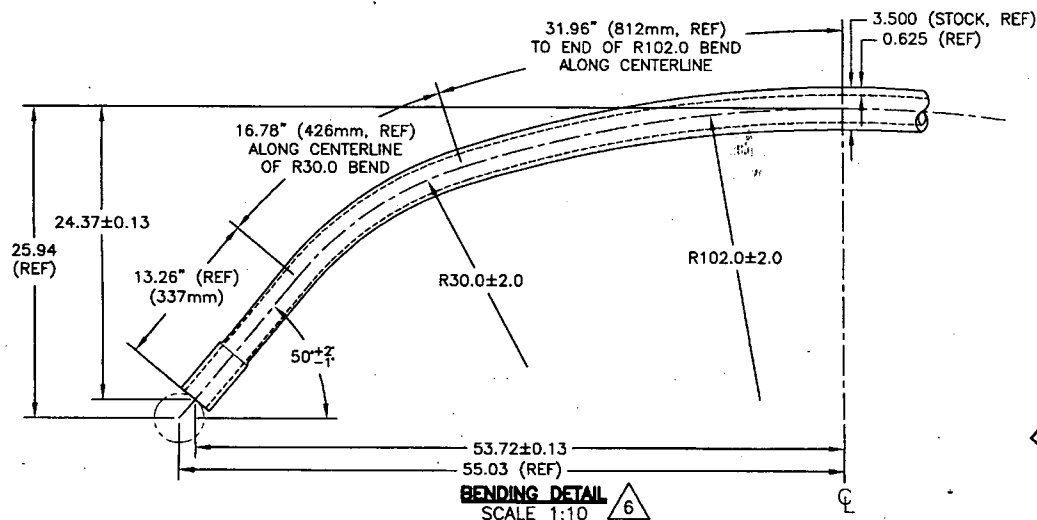
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

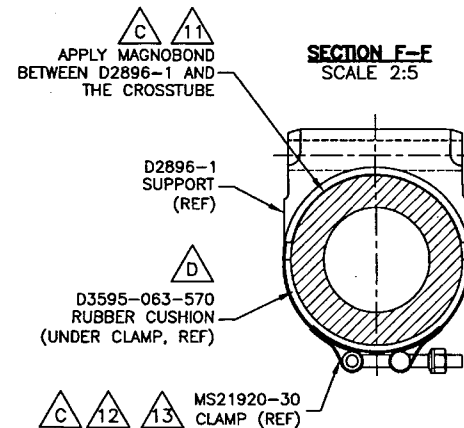
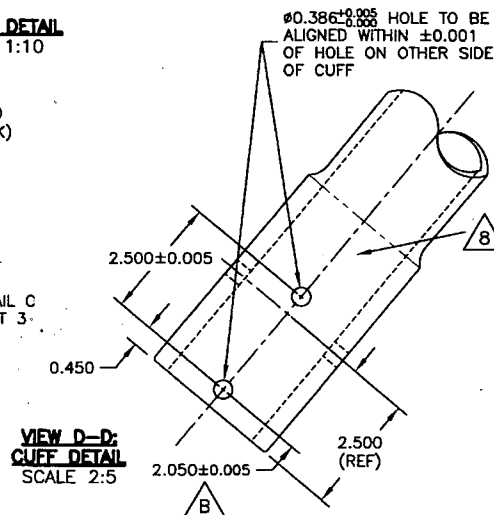
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RELEASE
07.04.24



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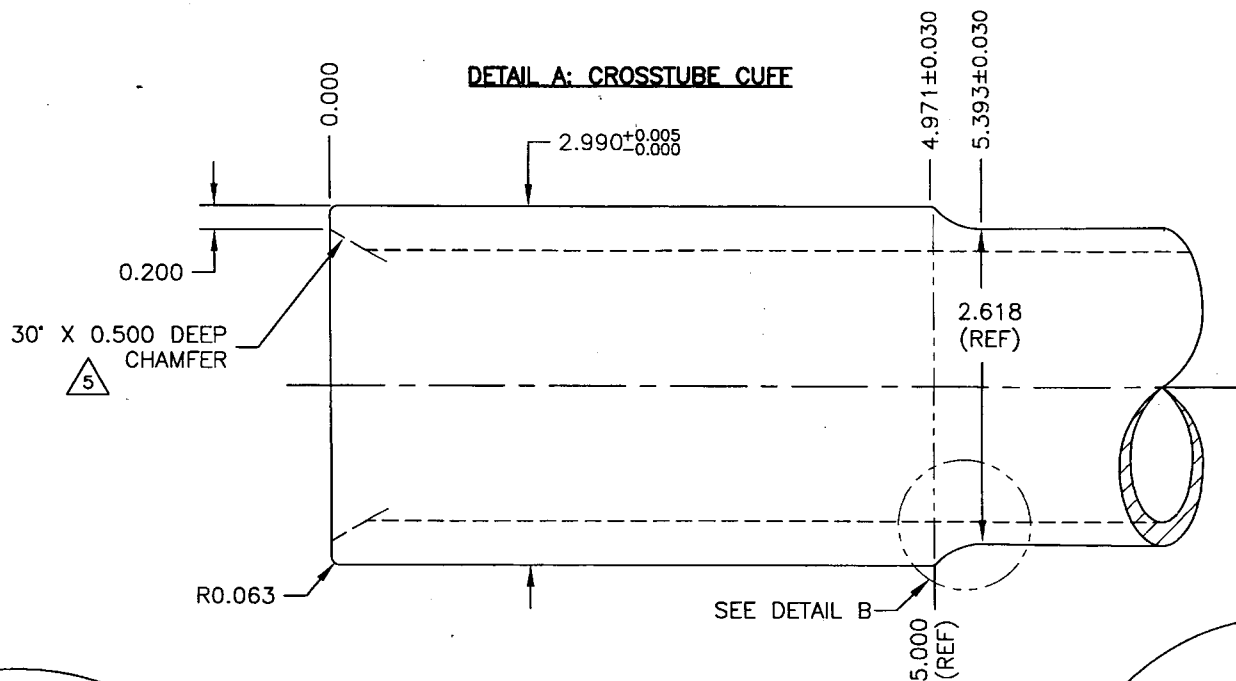
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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	GP	APPROVED	PH	DRAWING NO. D412-664-243	REV. D SHEET 2 OF 3
DATE	07.03.09	TITLE	CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE	1:10

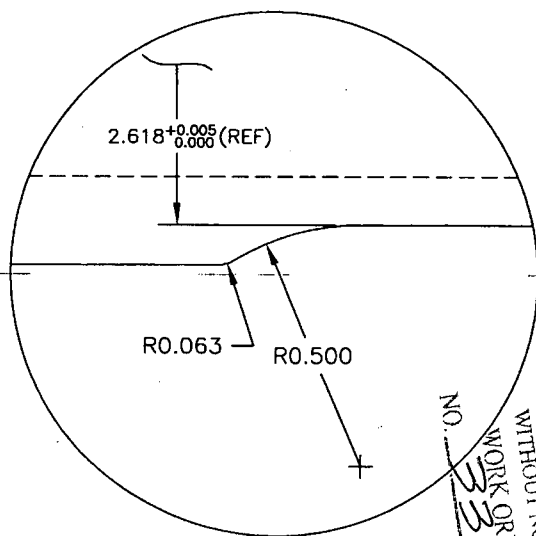
NO. 33328
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07-04-24
PER ECN 989

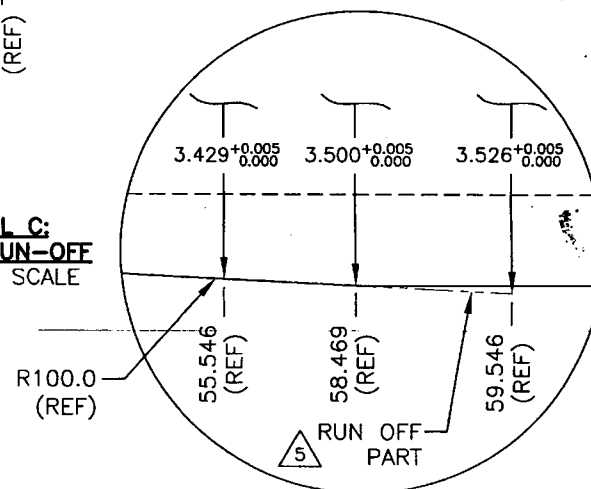
DETAIL A: CROSSTUBE CUFF



**DETAIL B: CUFF
TRANSITION
SCALE: 4:1**



**DETAIL C:
TAPER RUN-OFF
NOT TO SCALE**



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED J	APPROVED JH	DRAWING NO. D412-664-243	REV. D SHEET 3 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1



LIQUID PENETRANT TEST REPORT

P- 08662

PAGE 1 OF 1

CLIENT Dart Aerospace DATE October 16, 2007 TIME AM ☐ PM ☒
ATTENTION Bill Beckett ACUREN JOB NO. 188-07-01248
ADDRESS 1270 Aberdeen Street POWO No. _____
HAWKESBURY, Ontario K6A 1K7 WORK LOCATION as shown
PROJECT Cross Tube inspection ACCEPTANCE STD. E1417-99 REV./DATE 99
ITEM(S) EXAMINED Inspection of High Aft X Tube 412, 206L AFT X-Tube and 206L
FWD X-Tube as listed below

JOB DESCRIPTION _____ PROCEDURE No. E1417 REV./DATE 99 TECHNIQUE No. LT-XXXX-XXX REV./DATE _____
PART NO. D412664203, D206667203, D206667103 MATERIAL 7075 Aluminum THICKNESS < 1/2"
SCOPE 100% examination using Type I, Method A, Level 2 Penetrant examination
per Standard ASTM E1417-99

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIER
FAMILY BRAND Magnaflux Batch # 07F046 BLACK LIGHT S/N 10645 ☒ OUTPUT > 1000 μ W/cm² ☒ AMBIENT < 2 fc
PENETRANT Z167 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFAC
PENETRANT REMOVER Water MINIMUM DRY TIME > 10 MIN. OTHER _____
DEVELOPER NA MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE _____
DEVELOPER TYPE NA ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY Black light Calibration Due March 4, 2008

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
4 pieces P.N. D206667103			
Jbb #'s, 34138, 34137, 33156, 34140			
1 piece P.N. D412664203 Jbb # 33538			
1 piece P.N. D206667203 Jbb # 34144			
All 6 pieces Acceptable			

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of it data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jason Munro DTR # 188-07-01248
TECHNICIAN (SIGNATURE): Mark Westover SIGNATURE _____
NAME (PRINT): Mark Westover REPORT REVIEWED BY: _____
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 5323 CGSB REG. NO. _____

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005



LIQUID PENETRANT TEST REPORT

P- 08665

PAGE 1 OF 1

CLIENT: Dart Aerospace
ATTENTION: Bill Beckett
ADDRESS: 1270 Aberdeen Street
Hawkesbury Ontario K6A 1K7
DATE: October 19, 2007
ACUREN JOB NO.: 187-07-01157
PO/NO NO.:
WORK LOCATION: as shown
ACCEPTANCE STD: E1417-99
REV./DATE: 99

PROJECT: Cross Tube Inspection
ITEM(S) EXAMINED: Inspection of X-tube assemblies, 212/205 high Fed, 212/205 High AFT, 206L Fwd, 412 High AFT, 212/205 high Fed, as listed Below

OB DESCRIPTION: PROCEDURE NO. LT-0002 REV./DATE: E1417-99
TECHNIQUE NO. LT-0002 REV./DATE:
ART NO.: X-Tube assemblies as listed. MATERIAL: 7075 Aluminum THICKNESS: < 1/2"
SCOPE: 100% examination of all outer surfaces per standard ASTM E1417-99
Type I, Method A, Level 2.

TEST DETAILS
METHOD: ☒ FLUORESCENT ☐ VISIBLE
WATER WASH: ☒ SOLVENT REMOVABLE: ☐ POST EMULSIFIED: ☐
FAMILY BRAND: Magnaflux Batch # 07F046
BLACK LIGHT S/N: 8168
OUTPUT > 1000 μ W/cm²
AMBIENT < 2 fc
PENETRANT: Zyglo ZL67 MINIMUM DWELL TIME: 10 MIN.
LIGHTING EQUIP.: ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER: Water MINIMUM DRY TIME: > 10 MIN.
OTHER:
DEVELOPER: NA MINIMUM DWELL TIME: 10 MIN.
LIGHT METER S/N: 1098866 CAL DUE DATE: 8/9/13
DEVELOPER TYPE: ☐ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION: ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE: ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS-		<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL	
ITEM	COMMENTS	ACCEPT	REJECT
P.N. D212664100 x 1 piece	Job # 34929		
P.N. D212664201 x 1 piece	Job # 30420		
P.N. D206667103 x 2 pieces	Job #'s 34926 and 34139		
P.N. D412664203 x 1 piece	Job # 33537		
P.N. D212664101 x 2 pieces	Job #'s 34931 and 34930		
All Seven (7) Units Acceptable.			

Scope of Services
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SIGNATURES
CLIENT REPRESENTATIVE: [Signature] DTR # 187-07-01157
TECHNICIAN (SIGNATURE): [Signature]
NAME (PRINT): Mark Westover
CGSB LEVEL 2 SNT LEVEL 2
CGSB REG. NO. 5323
REPORT REVIEWED BY:
NAME INITIALS
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL SNT LEVEL
CGSB REG. NO.